

Date: Monday, 4/24/2006 10:25:21 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : FUEL PURGE CANISTER
 Job Number : 26761
 Estimate Number : 10440
 P.O. Number : N/A Part Number : D3262041
 This Issue : 4/24/2006 S.O. No. : N/A Drawing Number : D3262 REV B
 Prsht Rev. : NC Project Number : N/A
 First Issue : N/A Type : MACHINED PARTS Drawing Revision : B
 Previous Run : 26416 Material : N/A
 Written By : See Comment Below Due Date : 5/15/2006 Qty: 2 Um: Each
 Checked & Approved By : 9806104.24
 Comment : Est. C 05.03.10 Removed P/O for liquid penetrant inspection K
 J/JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 26761A FUEL PURGE CANISTER



Comment: Sub-Component FUEL PURGE CANISTER

2.0 26761B FUEL PURGE CANISTER



Comment: Sub-Component FUEL PURGE CANISTER

3.0 D32621 Tube



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Tube

Pick:

Qty Part Number Description Batch

1 D-3262-1 Tube 26761A

9806-05-17 2

4.0 D32623 Cap



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Cap

Pick:

Qty Part Number Description Batch

2 D3262-3 Cap 326761B

9806-05-17 2

5.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld canister assembly as per Dwg D3262 using DT8739 to align fillings

Pick: Qty Part Number Description Batch

A/R Aluminum Rod m19173

9806-05-17 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 4/24/2006 10:25:22 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FUEL PURGE CANISTER

Job Number: 26761

Part Number: D3262041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5/9

WELD INSPECTION



AD 06-06-03

Comment: WELD INSPECTION

2006.05 (2)

PTO

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

H.M 06-06-14

(2)

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

1-Powder Coat Gloss White (Ref: 4.3.5.1) as per QSI 005 4.3

2-Ensure to mask threads

a.m 06-06-15

(2)

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FC 06 06 15

(2)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with P/N and B/N as per Dwg using a permanent fine point marker, then Stock

Location:

AL 06/06/15 (2)

11.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

SD 06/06/16 (2)

Job Completion



W 06.06.16

✓

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
060609	6	Add pressure test as per Dwg to step for inspection. permanent change.	<i>[Signature]</i>	06.06.09	2	<i>[Signature]</i>	<i>[Signature]</i> 060609

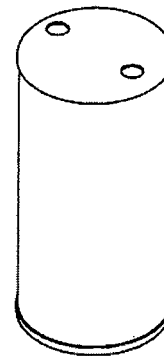
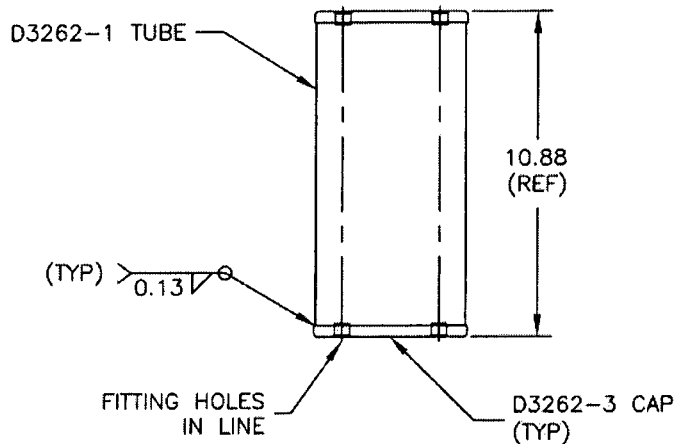
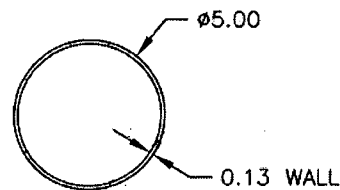
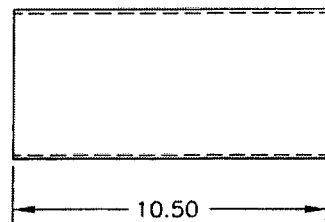
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: *[Signature]* Date: 06/06/16
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN R4	DRAWN BY R4	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3262	REV. B SHEET 1 OF 2
DATE 05.02.14		TITLE FUEL PURGE CANISTER	SCALE 1:1
A	04.05.06	NEW ISSUE	
B	05.02.14	ADD PRESSURE TESTING OPTION	

RELEASED
05.02.14**D3262-041 CANISTER ASSEMBLY****1 D3262-1 TUBE****D3262-041:**

- 1) MATERIAL: 6061-T6 (WW-T-700/6 OR QQ-A-200/8 OR QQ-A-225/8)
TUBING 5.00 OD x 0.125 WALL (6061T6T5.000W.125)
- 2) WELD PER QSI 004.
- 3) LIQUID PENETRANT INSPECT PER ASTM E1417 LEVEL 1 OR PRESSURIZE TO 10 PSI AND SUBMERGE UNDER WATER TO CHECK FOR LEAKS
- 4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 8) IDENTIFY WITH DART P/N & B/N USING FINE POINT PERMANENT INK MARKER

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WITHOUT NOTICE

WORK ORDER

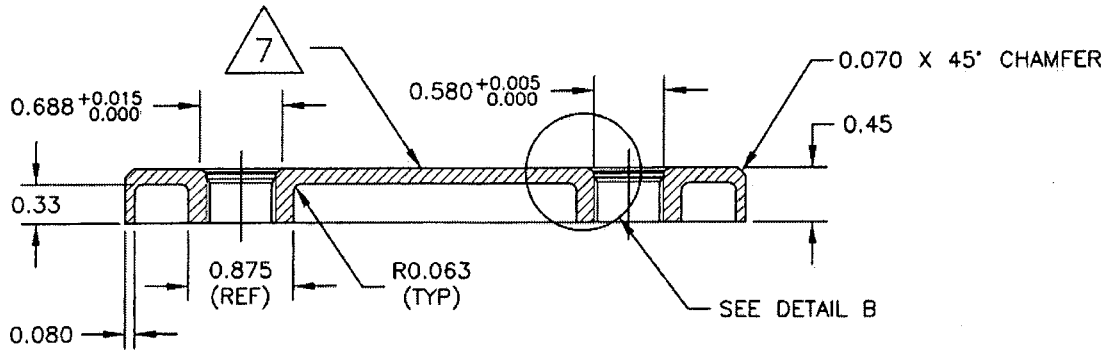
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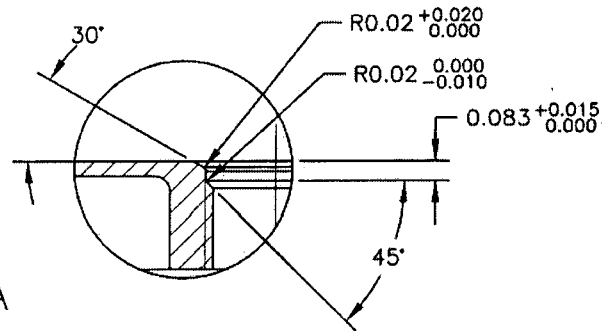
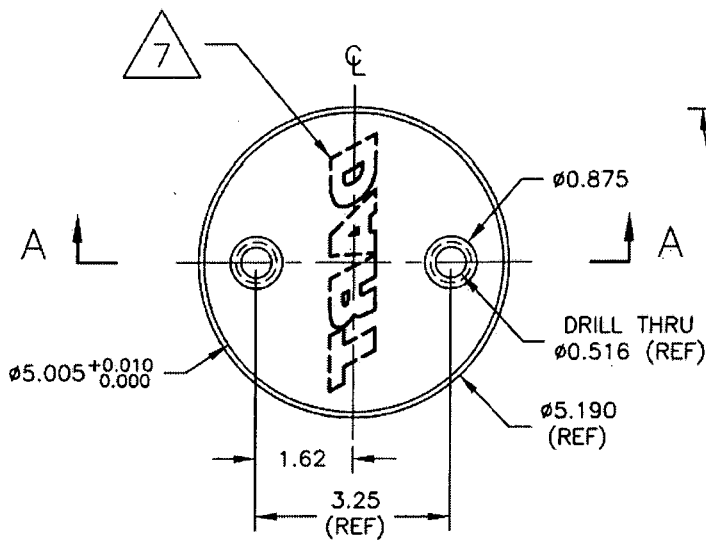
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DART

DESIGN RT	DRAWN BY RT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D3262	REV. B SHEET 2 OF 2
DATE 05.02.14	TITLE FUEL PURGE CANISTER		SCALE 1:3



SECTION A-A
SCALE 2:3



DETAIL B
SCALE 4:3

D3262-3 CAP

RELEASED
05.02.14

D3262-3

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8) BAR
(REF. DART SPEC. M6061T6B)
- 2) TAP HOLE 9/16-18 UNF-3B PER MIL-S-8879
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) PART IS SYMMETRIC ABOUT CENTERLINE
- 7) ENGRAVE DART LOGO AS SHOWN USING 0.75 HIGH x 0.010 DEEP
(MAX) LETTERS WITH (MIN) TOOL RADIUS OF 0.25

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